



## **TWECO FUSION™**

*Air-Cooled MIG Guns*



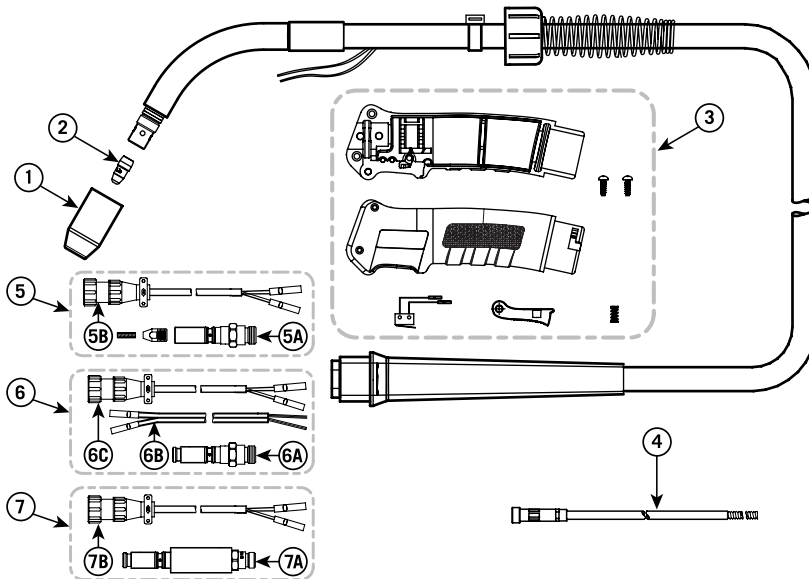
- Ideal for light to medium gauge work in auto-body, agriculture, architectural metal work, off-road vehicles, repair maintenance and general light fabrication.
- Full range up to 250 Amps @ 80% Duty Cycle.
- Features new high performance Velocity™ Consumables.
- CE rated outputs and duty cycles.
- Best in class performance.
- Built tough and designed to last.

**Tweco.com**

## **More Buy For Your Buck!**

U.S. Customer Care: 800-426-1888  
Canada Customer Care: 905-827-4515  
International Customer Care: 940-381-1212

- Typical Applications: Light Fabrication, Welding of HVAC, Architectural Metal Work, DIY, Hobby, Farm and Autobody
- Operator Appeal with Ergonomic Handle with Diamond Pattern for Better Grip
- Uses New High Performance Velocity™ Consumables
- Long-life Microswitch Trigger Design
- Rugged with Steel Spring Strain Relief



### SPARE PARTS LIST

No.	Description	Part No.	Stock No.
1	Velocity™ Nozzle	Refer to Velocity Consumables Chart at bottom of next page.	
2	Velocity™ Contact Tip		
3	Handle / Trigger Repair Kit	F80	2020-2025
4	Conduit Assembly*	WS42-3035-15	1420-1140
5	5A Miller® Rear Connector	350-174MH	2035-2111
	5B Miller® & Lincoln® Control Wire & Plug	WM354-M	2030-2075
6	6A Tweco® Rear Connector	350-174H	2035-2110
	6B Tweco® Control Wire & Plug	35K-350-1	2000-2352
	6C Thermal Arc® Control Wire	WS-354-TA-LC	2060-2141
7	7A Lincoln® Rear Connector	350-174HXL	2035-2116
	7B Miller® & Lincoln® Control Wire & Plug	WM354-M	2030-2075

\*Refer to Tweco Catalog No. 64-2103 for additional options.

## TWECO® VELOCITY™ MIG Welding Consumables

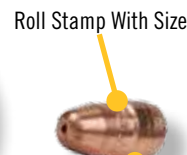
- Solid copper conductor path with fewer connections
- Optimized electrical surface contact
- Optimized wire feedability with centered liner
- Fewer consumable parts to replace – lower cost of ownership
- Easy to change Velocity tips – No threads, no tools required
- Tips can be rotated to optimize life requiring fewer changes
- Superior welding performance from a smooth, stable arc

### VELOCITY™ NOZZLE



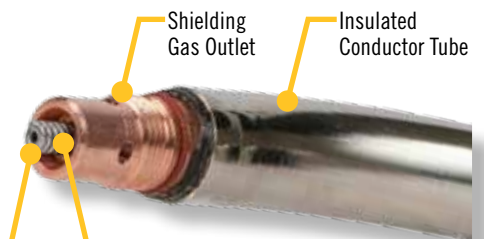
Heavy Duty Copper  
Large Copper to Copper Surface Contact for Superior Thermal and Electrical Efficiency

### VELOCITY™ CONTACT TIP



Roll Stamp With Size  
Perfectly Centered Liner

### CONDUCTOR TUBE

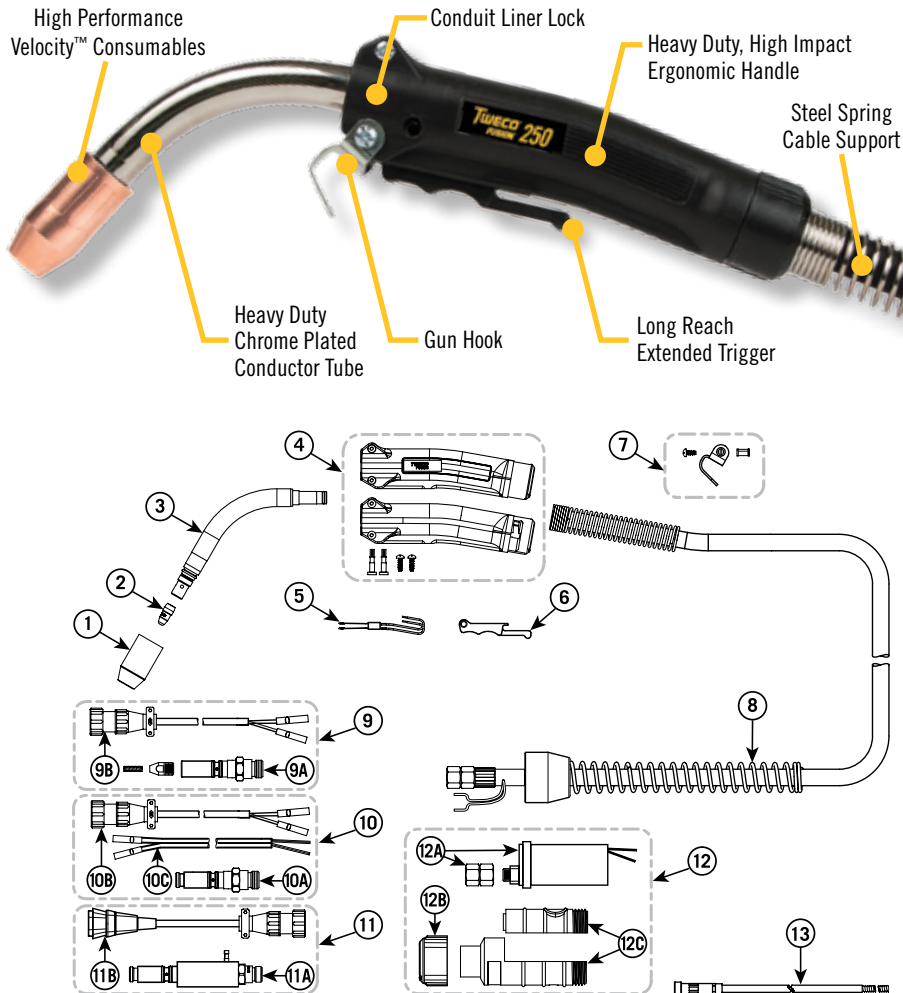


Shielding Gas Outlet  
Conduit Liner Seats Inside the Tip for Superior Feedability

# TWECO FUSION™ 250

250 Amps @ 80% Duty Cycle

- Typical Applications: General Light Fabrication, Production Welding, Auto-Body, RV/Campers, Farm Equipment
- Operator Appeal with Ergonomic Handle with Extended Trigger Length
- Uses New High Performance Velocity™ Consumables
- High Output / High Duty Cycle
- Rugged with Steel Spring Strain Relief



## SPARE PARTS LIST

No.	Description	Part No.	Stock No.
1	Velocity™ Nozzle	Refer to Velocity Consumables Chart below.	
2	Velocity™ Contact Tip		
3	Velocity™ 45° Conductor Tube	FVCT-S45	1620-1369
	Velocity™ 60° Conductor Tube	FVCT-S60	1620-1368
4	Handle Halves w/screws	F84	2060-2126
5	Trigger – Standard	ELC84	2060-2647
6	Trigger Blade Assembly	ELC94-BL	2060-2671
7	Gun Hanger	152	2020-2152
8	Cablehoz Assembly – 10 ft (3 m)	MS210	1720-2115
	Cablehoz Assembly – 12 ft (4 m)	MS212	1720-2116
	Cablehoz Assembly – 15 ft (5 m)	MS225	1720-2117
	Cablehoz Assembly – 25 ft (8 m)	MS225	1720-2118
	Cablehoz Assembly, Euro-Kwik – 12 ft (4 m)	MS212X	1720-2107
	Cablehoz Assembly, Euro-Kwik – 15 ft (5 m)	MS215X	1720-2108
	Cablehoz Assembly, Euro-Kwik – 25 ft (8 m)	MS225X	1720-2109
	Cablehoz Front Mechanical Connector Replacement Kit	MS102-RK	2060-2132
	Cablehoz Rear Mechanical Connector Replacement Kit	MS172-RK	2060-2134
	Cablehoz Front Mechanical Connector Replacement Kit for Euro-Style	172X-M	2060-2181
9	Miller® Rear Connector	350-174-MH	2035-2111
	Miller® Control Wire & Plug	WM-354M	2030-2075
10	Tweco® Rear Connector	350-174H	2035-2110
	Tweco® Control Wire & Plug	MS354-TAJ	2060-2139
11	Thermal Arc® Control Wire & Plug	WS-354-TA-LC	2060-2141
	Lincoln® Rear Connector	350-174LH	2035-2112
12	Lincoln® Control Wire & Plug	MS-354DS-LJ	2060-2137
	Euro-Kwik Connection Assembly	174EX-1	2040-2276
13	Euro-Kwik Nut	174X-2	2040-2177
	Euro-Kwik Connector Case	X6RC	2060-2006
13	Conduit Assembly*	*	*

\*Refer to Tweco Catalog No. 64-2103 for specific parts.

## TWECO FUSION™ MIG Guns come standard with Velocity™ Consumables

VELOCITY™ CONSUMABLES	
Velocity™ Nozzles	Velocity™ Contact Tips
VNS-50F	VTS-23
VNS-50	VTS-30
VNS-37F	VTS-35
VNS-37	VTS-40
VNS-62F	VTS-45
VNS-62	VTS-364
VNS-75FAS	VTS-364
VNS-FC	VTS-52
	VTS-116
	VTS-116
	VTS-564

VELOCITY™ NOZZLE IDENTIFICATION	
S=Small Nozzle, M=Medium Nozzle, L=Large Nozzle	Orifice Opening Size: 37=3/8" 62=5/8" 50=1/2" 75=3/4"
Blank=Threaded, S=Slip	
Blank=Standard, H=Heavy Duty	
Blank=Std Recess, F=Flush, P=Protrude, R=Recess 1/4" (6.35 mm)	
FAS=Spot Weld FC=Flux Core	

VELOCITY™ CONTACT TIP IDENTIFICATION	
S=Small, M=Medium, L=Large	Blank=CU, RZ=CHROM ZIRC, RS=SILVER ZIRC
T=Tapered, Blank=None	
A=Aluminum, Blank=Other	
Wire Size: 23=0.023" 30=0.030" 35=0.035" 40=0.040" 45=0.045"	
364=3/64" 116=1/16" 564=5/64" 332=3/32" 764=7/64" 18=1/8"	

## TWECO FUSION™ MIG GUNS SELECTION CHART

Amps	MIG Gun	DIY/Hobby	Farm	MRO	Autobody	Light Fab
≤ 150 Amps	Best Fit: Tweco Fusion 140 Alternate Fit: Tweco Fusion 180	Best	Good	Good	Best	
150 – 200 Amps	Best Fit: Tweco Fusion 180 Alternate Fit: Tweco Fusion 220	Best	Best	Best	Best	
200 – 250 Amps	Best Fit: Tweco Fusion 220 Alternate Fit: Tweco Fusion 250	Good	Best	Best	Best	Best
≥ 250 Amps	Best Fit: Tweco Fusion 250		Best	Best	Best	Best

## TWECO FUSION™ MIG GUNS

Rear Connection	Tweco Fusion™ 140 Part Number / Stock Number	Tweco Fusion™ 180 Part Number / Stock Number	Tweco Fusion™ 220 Part Number / Stock Number	Tweco Fusion™ 250 Part Number / Stock Number
Thermal Arc® (8 Pin)	F140TA-10-3035 1017-1321	F180TA-12-3035 1017-1332	F220TA-12-3035 1023-1261	FV215-TA-3545 1023-1097
Tweco® (4 Pin)	F140T-10-3035 1017-1320	F180T-12-3035 1017-1331	F220T-15-3035 1023-1260	FV215-3545 1023-1061
Miller®	F140M-10-3035 1017-1319	F180M-12-3035 1017-1330	F220M-15-3035 1023-1259	FV215-M-3545 1023-1069
Lincoln®	F140L-10-3035 1017-1318	F180L-12-3035 1017-1329	F220L-15-3035 1023-1258	FV215-L-3545 1023-1085
Euro-Kwik	F140X-10-3035 1017-1323	F180X-12-3035 1017-1334	F220X-15-3035 1023-1263	FV215-X-3545 1023-1091

## POWER SUPPLY COMPATIBILITY

Thermal Arc® Connector (8 Pin)	Tweco® Connector (4 Pin)	Miller® Connector	Lincoln® Connector	Euro-Kwik Connector
Thermal Arc® Fabricator 141i, 181i, 211i & 252i	Thermal Arc® Fabricator 140, 180, 190, 210, 251 & 281  Lincoln® SP100, SP100T, SP125 Plus, SP130, SP170T & SP170 Plus  Hobart® Beta Mig 170	Millermatic® 130, 130 XP, 135, 140, 150, 155, 175, 180, 185, 200, 210, 211, 212  Hobart® Handler 130XL, 210, Trek 180, Ironman™ 210	Lincoln® SP140T, SP180T, PowerMIG® 140C & 180C, Easy-Core™ 125, Pro-Core™ 125, Easy-MIG® 140, Weld-Pak 125HD, 140HD & 180HD, MIG-Pak™ 140 & 180, Easy-MIG® 180, Pro-MIG™ 140 & 180	ESAB® MigMaster® 160 & 173

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